

Date: Thursday, 02/04/2009 2:25:13 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FRAME  
 Job Number : 46833  
 Estimate Number : 13819  
 P.O. Number :  
 This Issue : 02/04/2009 S.O. No. :  
 Prsht Rev. : NC Part Number : D233015  
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D2330 REV G  
 Previous Run : Project Number : N/A  
 Material :  
 Due Date : 14/04/2009 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : JUL 0904-02  
 Comment : Est Rev:A 09.03.18 New Issue EC verified by:DD

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 1.0 M304TS0750W065 304 SQ Tube .75x.75x.065W



Comment: Qty.: 2.9085 f(s)/Unit Total : 2.9085 f(s)

304 SQ Tube .75x.75x.065W

batch: M111148

SAD 09-04-07

2.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Cut as per dwg D2330

2- Deburr and remove identification markings on tube

SAD 09-04-07 (1)

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 09-04-07 (1)

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Basket

AD 09-04-07 (1)

5.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/08

Job Completion



U 09.04.07

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2330-041	BASKET ASSEMBLY
3		X	D2330-043	LID ASSEMBLY
7	1		D2012-107	CLEVIS
8	4		D2235-1	RIB
9	2	2	D2252-1	FRAME
10	1	4	D2252-7	FRAME
11	2		D2253-1	LUG
12	2		D2254	GUSSET
13	1	1	D2327-3	BUSHING
14		1	D2329	LABEL PLATE
15	2	2	D2330-1	FRAME
16	1		D2330-5	FRAME
17	1		D2330-7	FRAME
18		1	D2330-15	FRAME
19	4	2	D2581	MOUNTING CHANNEL
20	3		D3748-1	HINGE HALF
21		3	D3749-1	HINGE HALF

G

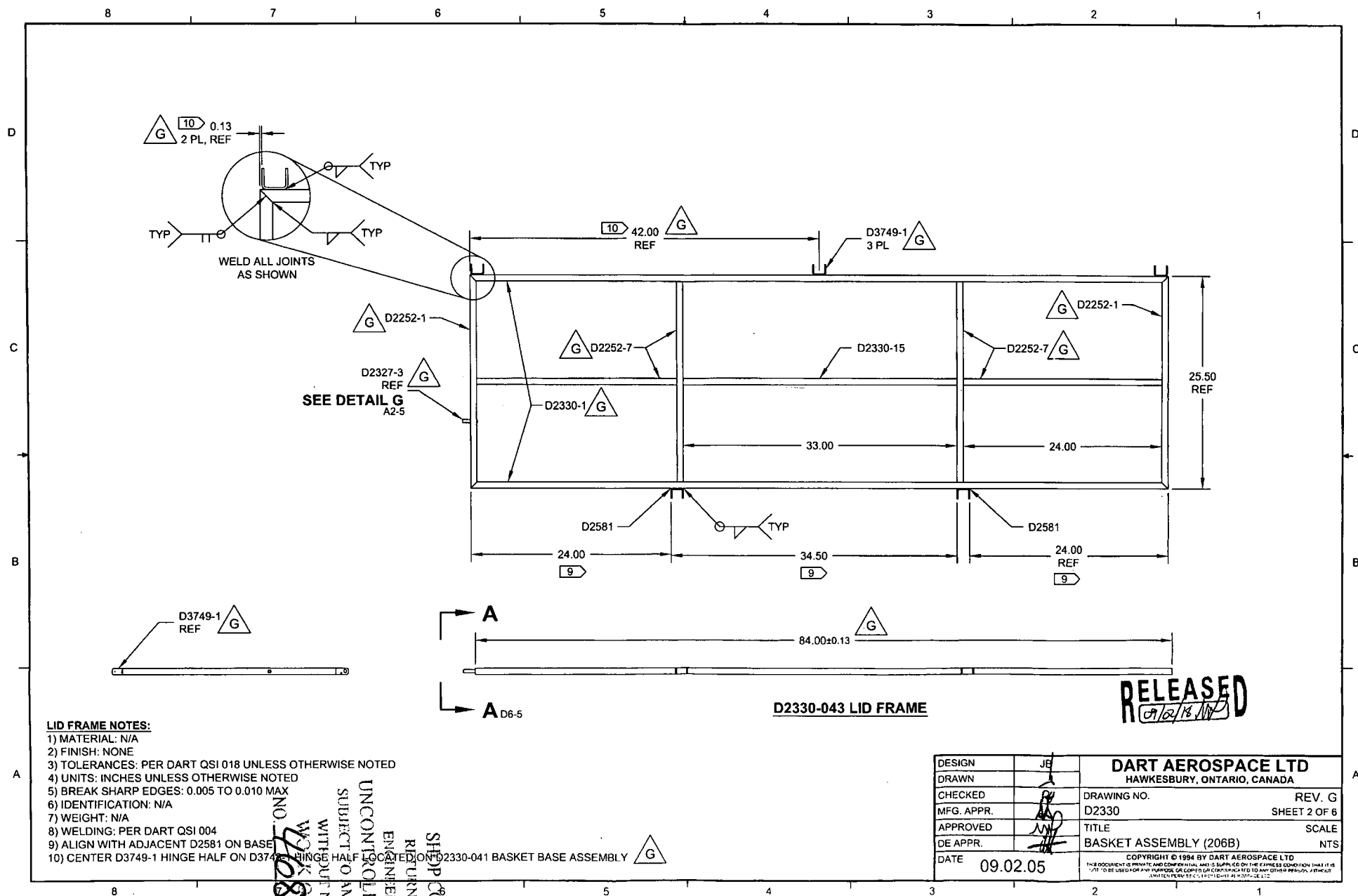
RELEASED  
01/24/80 MB

# NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

NO. 100833  
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G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 20 AND 21 REPLACE D2232-1/-3; STRETCHED LID FROM 83.27" TO 84.00"; ITEMS 9 & 10 REPLACE D2330-3/-9/-13; ITEM 13 (ON LID) REPLACES D2327-1; REORGANIZED ALL SECTION & DETAIL VIEWS. REASON: SEE PAR#09-006.	MB	09.02.05
F	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 6 ADDED. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1. D2253-1 WAS D2253 (NCR 533).	KE	05.11.10
D	MODIFIED LATCH, REDRAWN	KE	99.09.14
C	ADDED LATCH AND LABEL PLATE	BK	96.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JLB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JLB		
CHECKED	MB	DRAWING NO.	REV. G
MFG. APPR.	MB	D2330	SHEET 1 OF 6
APPROVED	MB	TITLE	SCALE
DE APPR.	MB	BASKET ASSEMBLY (206B)	NTS
DATE	09.02.05	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DRAWING IS PRIVATE AND CONFIDENTIAL. IT IS TO BE KEPT IN THE COMPANY'S FILES AND NOT TO BE LOANED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



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8 7 6 5 4 3 2 1

D

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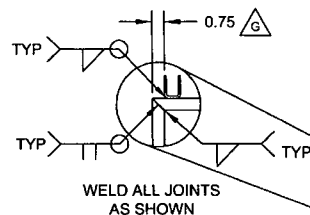
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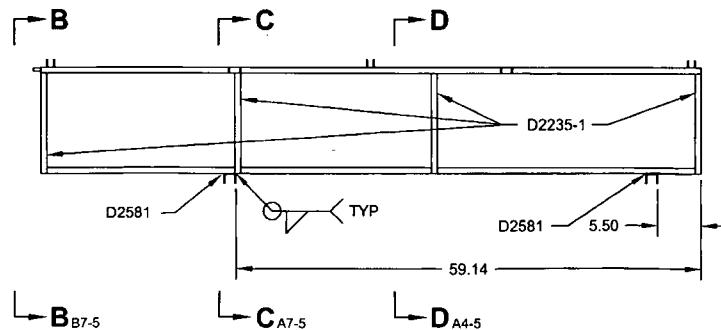
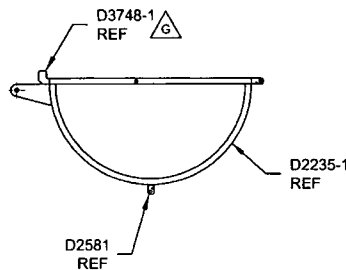
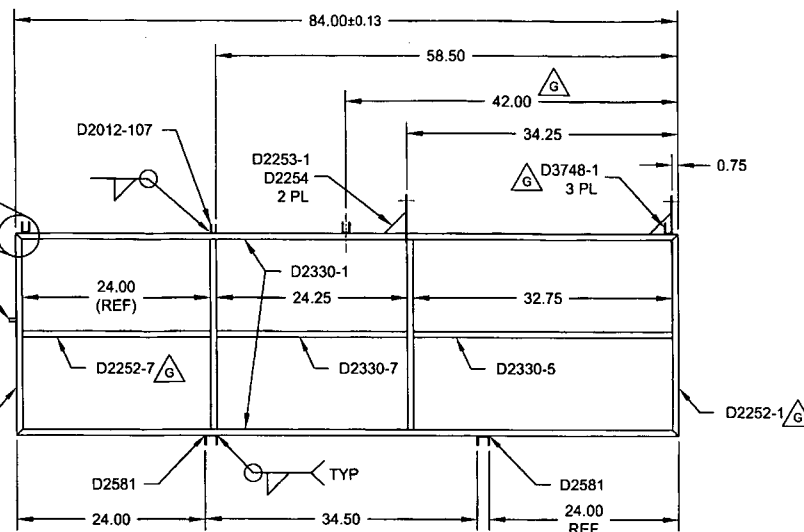
B

A



D2327-3  
REF  
SEE DETAIL G  
A2-5

D2252-1








**D2330-041 BASE FRAME ASSEMBLY**

**BASE FRAME NOTES:**

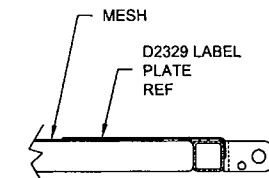
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

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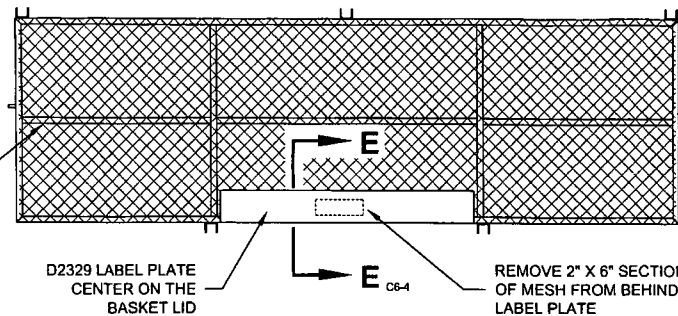
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2330	SHEET 3 OF 6
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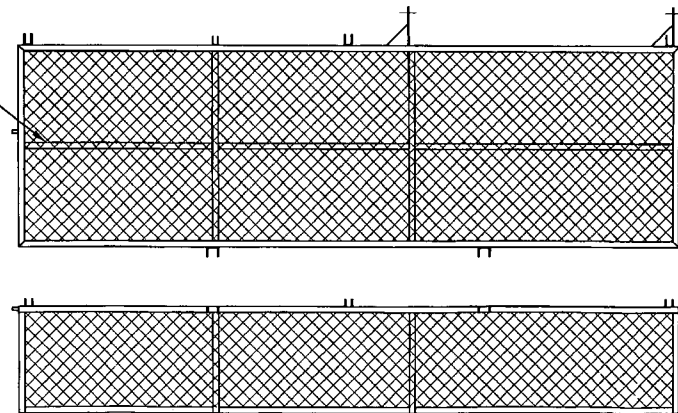


**SECTION E-E** C3-4  
VIEW ROTATED 90° CCW

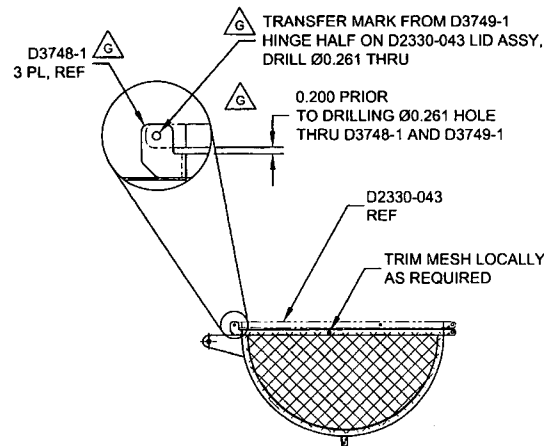
TACK WELD EACH  
STRAND END OF  
MESH TO FRAME



**D2330-043 LID ASSEMBLY**



**D2330-041 BASE ASSEMBLY**



**ASSEMBLY NOTES:**

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

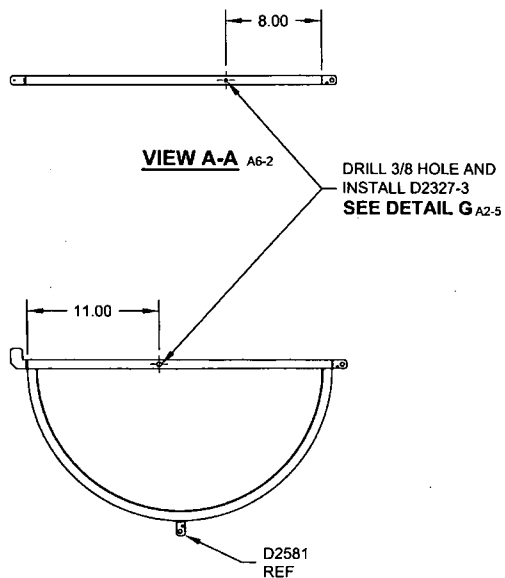
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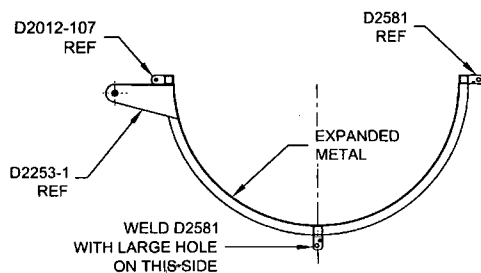
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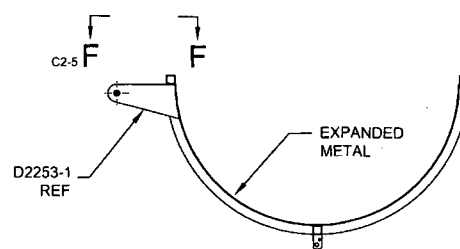
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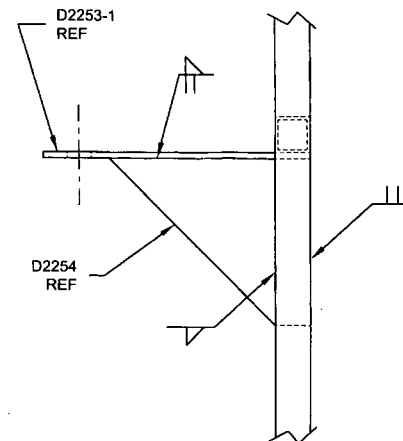
**VIEW B-B A5-3**



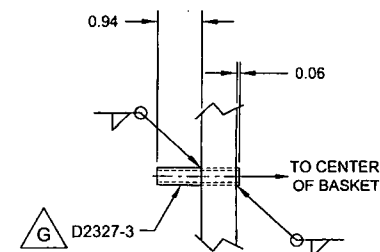
**SECTION C-C A4-3**



**SECTION D-D A3-3**



**VIEW F-F B6-5  
SCALE 4X**



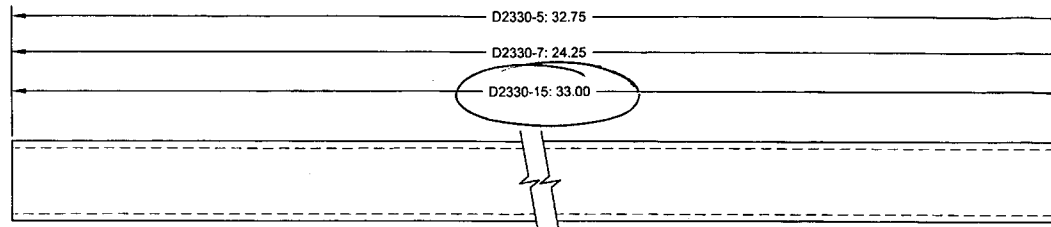
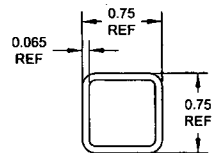
**DETAIL G  
SPACER INSTALLATION  
SCALE 4X**

C6-2  
C5-3  
C6-5

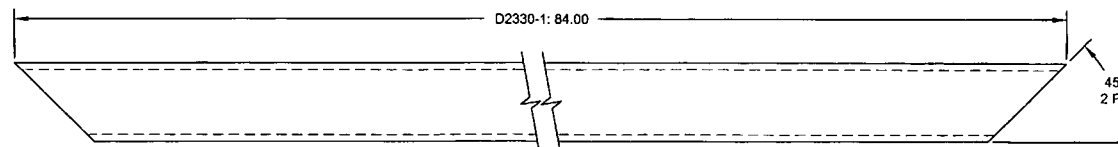
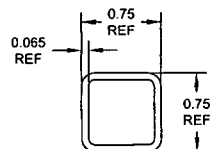
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**D2330-5 FRAME**  
**D2330-7 FRAME**  
**D2330-15 FRAME**



**D2330-1 FRAME**

**RELEASED**  
 9/2/18 JWB

- NOTES:**  
 1) FRAME MATERIAL: SEE SHEET 1  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: N/A

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